

Work Order ID 57929

Tuesday, April 20, 2010 11:12:59 AM



Item ID:	D3763-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	End Fitting Assembly					
Start Date:	4/20/2010	Start Qty:	10.00		Cust Item ID:	
Required Date:	4/23/2010	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>10-4-20</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3763	Rev B								
100	Pick Kit	0.00							
	Packaging								
Packaging	Memo	0.00							
110	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00							
	1-make a 0.063" chamfer on D3763-1 fitting before ass'y □ 2-assemble as per dwg D3763 using locating pin DT9039 □ *****ensure locating pin is in 0.221" hole***** □ 3-weld as per dwg D3763 QSI004 □ Alum. rod Batch: <u>1111311</u>								
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

10 05-05

10 04-27

10 04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

Sid 10/04/08

(410)

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

JS 10/04/29

(X10)

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

0.00

QC

Memo

Quality Control

10 - PK 10-4-29.

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Required Date: 4/23/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 25/A

0.00



Packaging

Memo

0.00

Packaging

PC 4/20/4 (10)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04

BS 10-5-04
(10)

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Picklist Print

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Work Order ID: 57929



Parent Item: D3763-041



Parent Item Name: End Fitting Assembly


Start Date: 4/20/2010

Required Date: 4/23/2010

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec
 IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC
 IPP Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3763-1		Manufactured	No			110	Each	5.0000	10.0000			
												
End Fitting												


10.04.27

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA **357931** 5
 56755 5

10

D3763-3		Manufactured	No			110	Each	6.0000	10.0000			
												
Tube												

10.04.27

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST251 **357930** 6
 56597 2
 57553 4

10

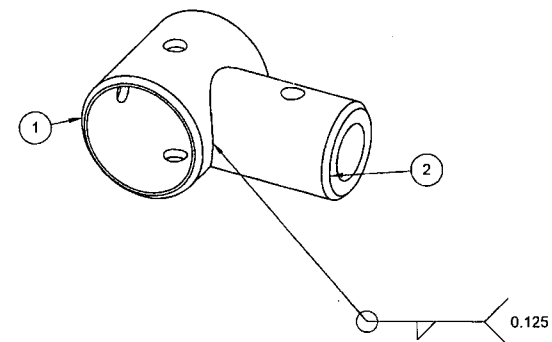
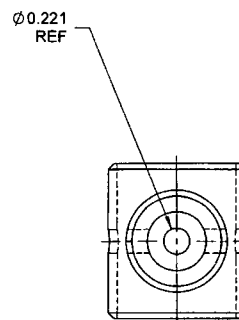
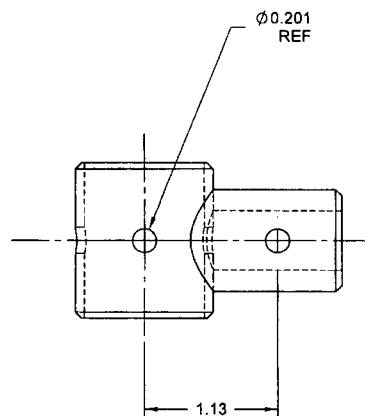
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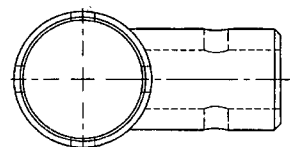
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#57929

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1



D3763-041 END FITTING ASSY

RELEASED
08.07.10

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) WELD: PER DART QSI 004

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3763	SHEET 1 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	END FITTING	NTS
DATE	08.06.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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